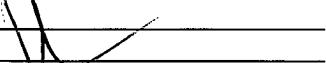
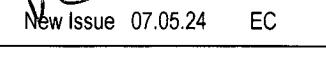


Date: Tuesday, 02/10/2007 12:57:54 PM
 User: Linda Lacelle

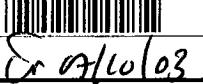
Process Sheet

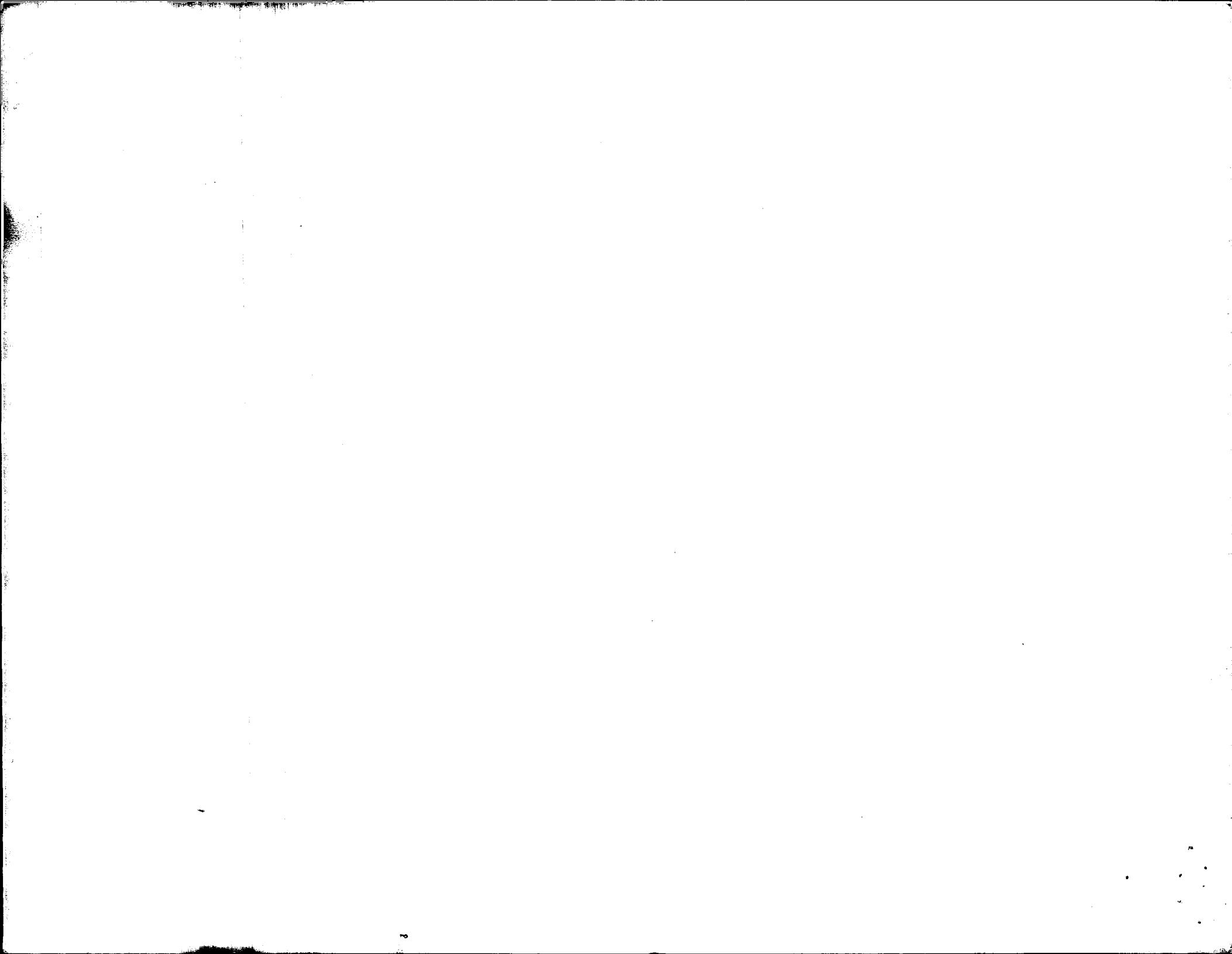
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 34966		Part Number	: D3560043		
Estimate Number	: 12883		Drawing Number	: D3560 UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 02/10/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 09/10/2007 Qty: 5 Um: Each		
Previous Run	: 34476					
Written By	: 					
Checked & Approved By	: 					
Comment	: Est Rev:A New Issue 07.05.24 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 PULL FROM STK:		
2.0	D3560043	ARM WELDMENT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) ARM WELDMENT  07.10.02		
3.0	D35921	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PLATE  07.10.02		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Weld assembly as per dwg D3560  07.10.02		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP  07.10.03		
6.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION  07.10.03		



Date: Tuesday, 02/10/2007 12:57:54 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34966

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM

01.10.03

(5)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM 01.10.03

5

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

AM 01.10.03

(5)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AM 01.10.03

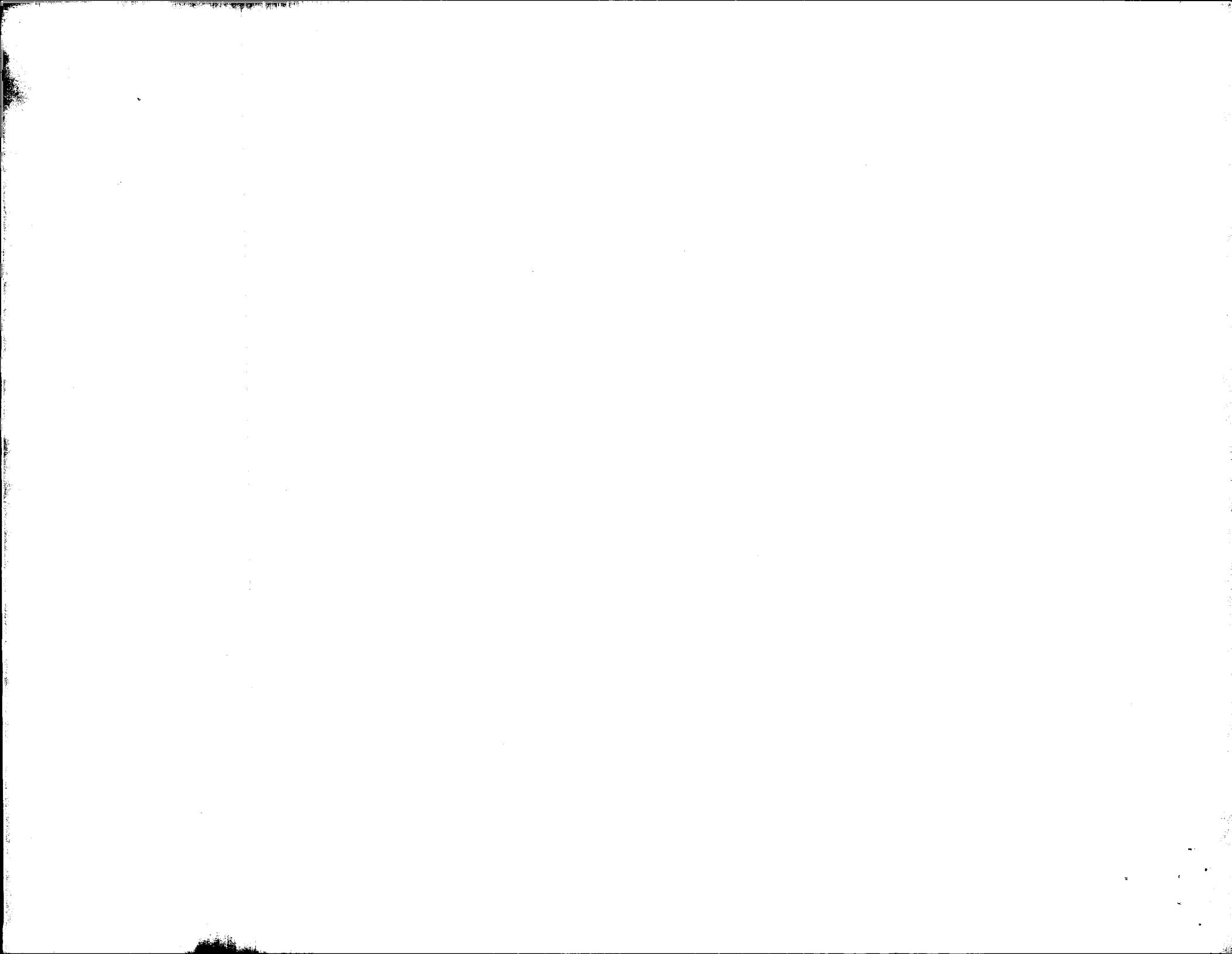
(5)

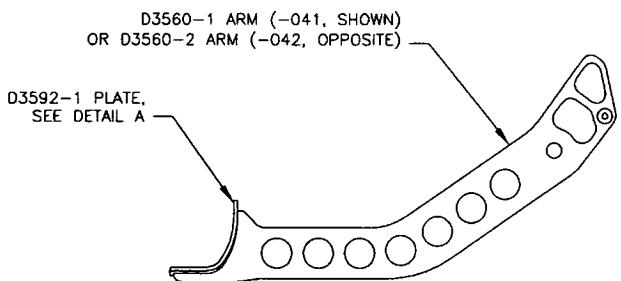
Job Completion



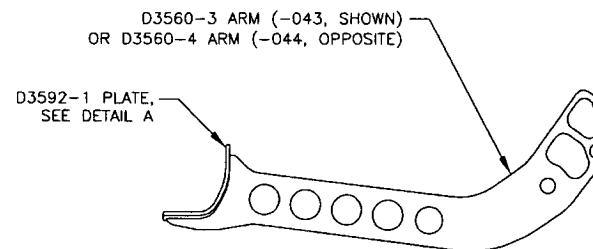
AM 01.10.05

→

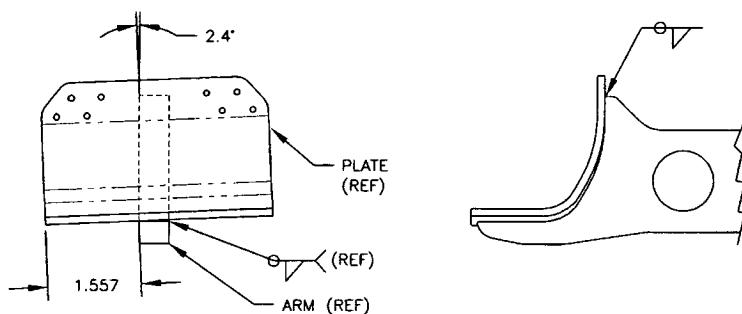




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

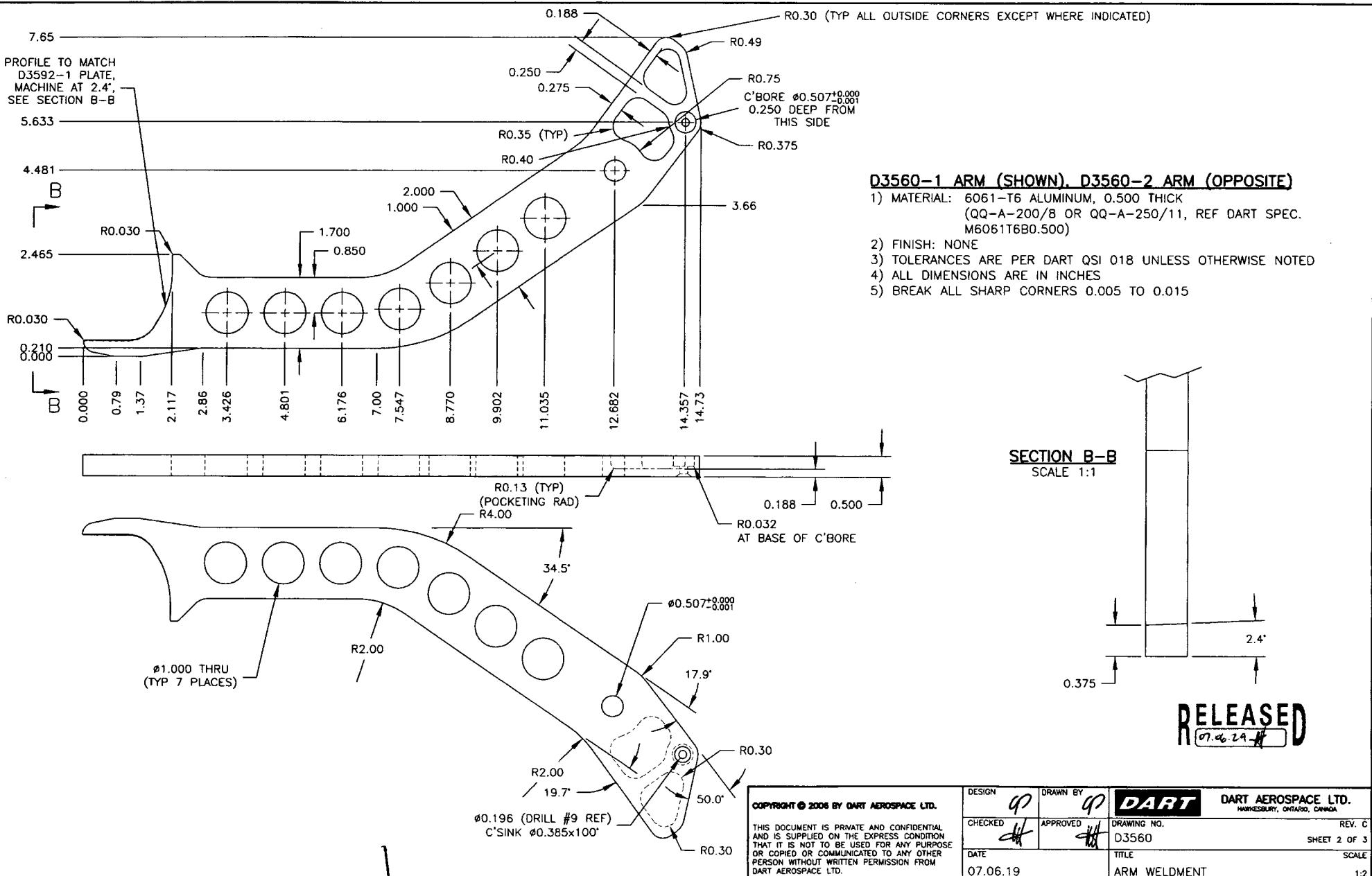
GENERAL NOTES

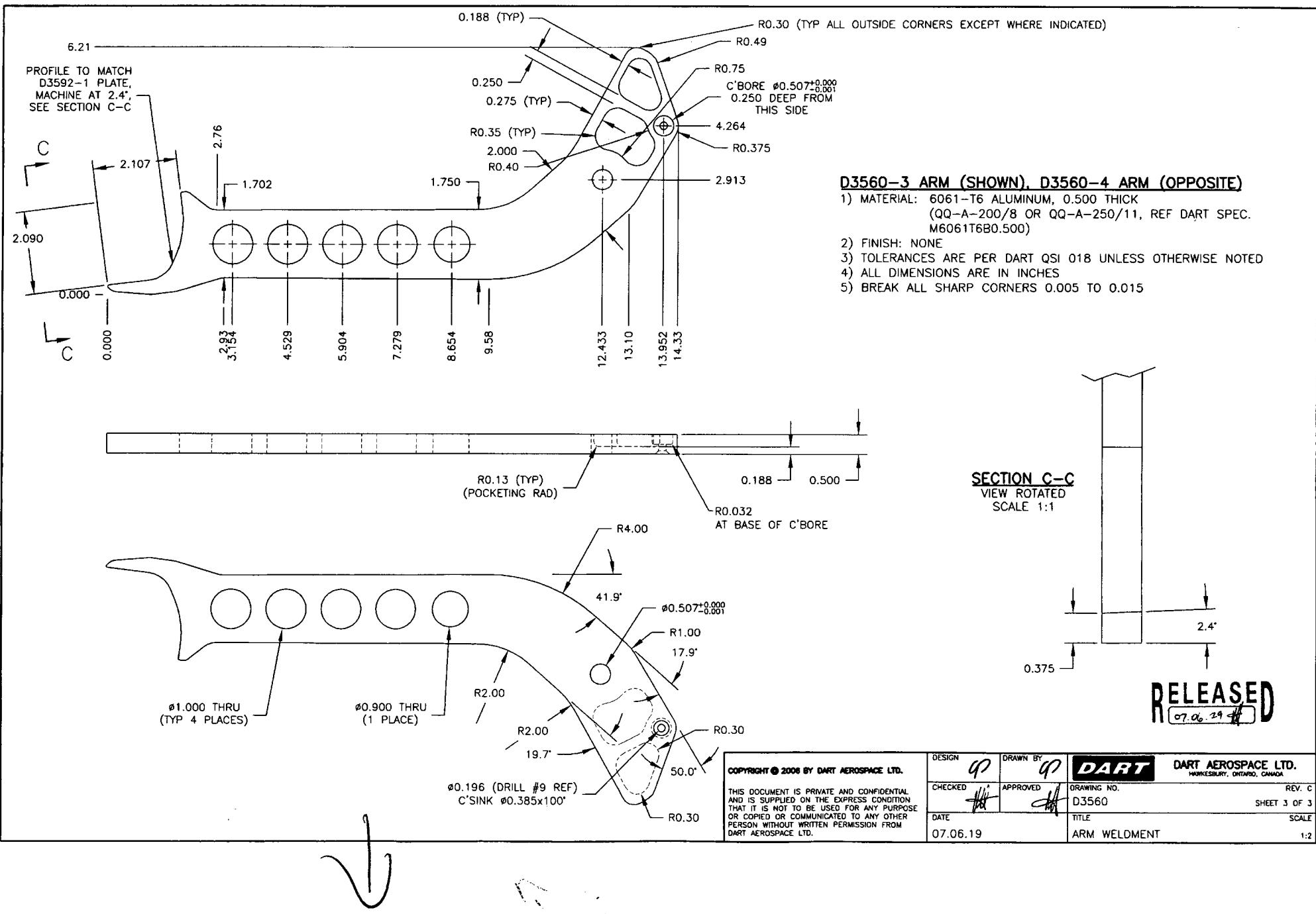
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

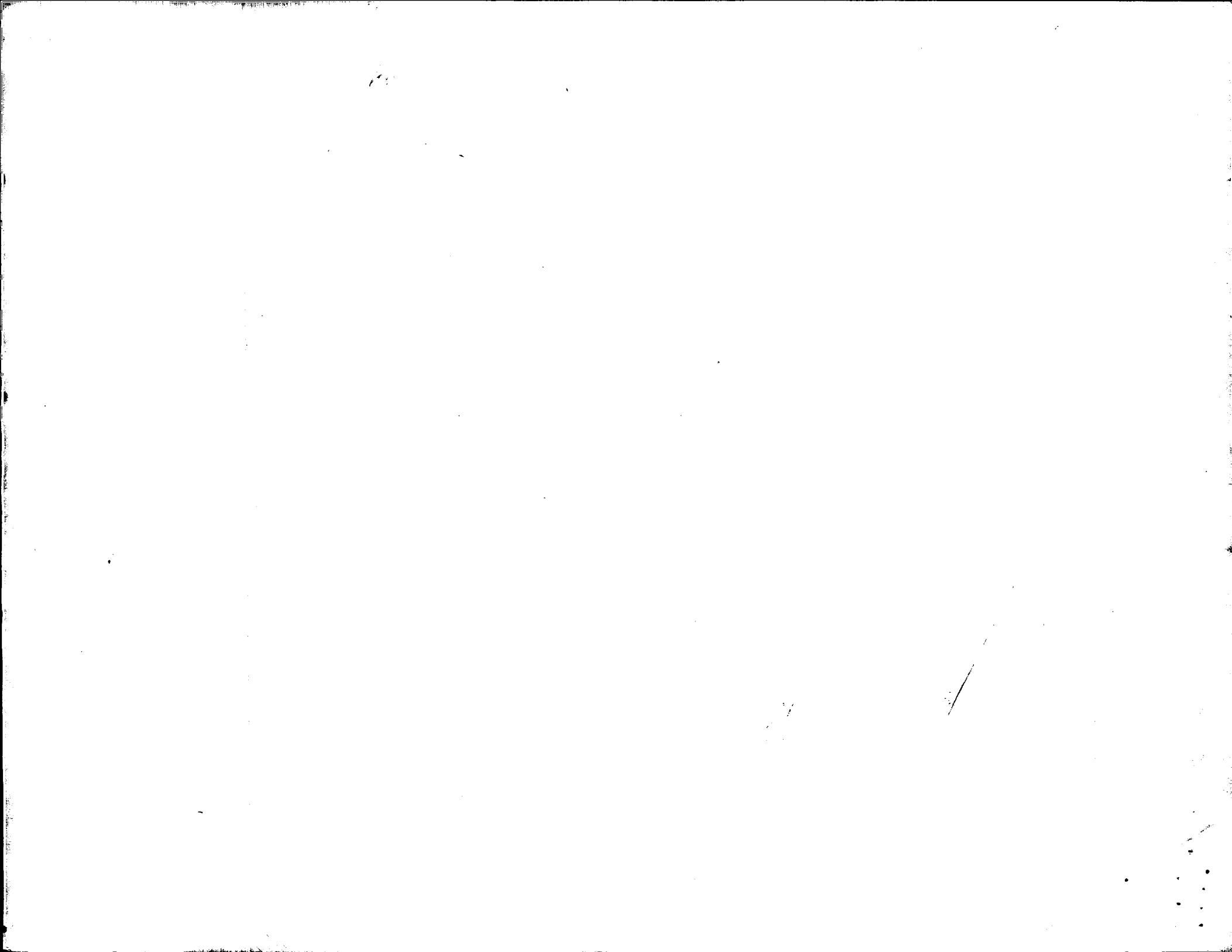
RELEASED
07.06.19

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
CHECKED	APPROVED	DRAWING NO. D3560 REV. C SHEET 1 OF 3
DATE		TITLE ARM WELDMENT SCALE 1:4
07.06.19		







W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.03	4.	(Qty 1) ARM IS TOO NARROW AT WELD BECAUSE OF GRINDING DURING RE-WELD	UP 07.10.03 per 081042	SCRAP, AND Replace Re-weld D3560-45: B = 32646	UP 07.10.03	UP 07.10.03	UP 07.10.03 per 081042	UP 07.10.03
			weld	D3560-45: B = 332646 ARM 081004	UP 07.10.03	UP 07.10.03	UP 07.10.03	UP 07.10.03
				Instruct lead to welding inspection	UP 07.10.03	UP 07.10.03		

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/04	to	Scrap all the parts that we reworked twice. (part D 32646) - Doors and airs	GP 07.10.04 per QSI 042	Scrap and destroy. Replace with all new parts. new welds QSI 042 004	PK 07.10.04	G 07/10/04	GP 07.10.04 per QSI 042	EN 07/10/04
			GP 07.10.04 per QSI 042	Re inspect weld QCI 9 Re inspect QCI 5	PD 07/10/04	G 07/10/04	GP 07.10.04 per QSI 042	EN 07/10/04

NOTE: Date & initial all entries